

Work Order ID 69188

Wednesday, May 04, 2011 11:40:50 AM

Page 1

Item ID: D3281-2L08

Accept

Setup Start

Revision ID:

Stop

Item Name: Floor Protector, Fwd RH

Start Date: 5/4/2011 Start Qty: 4.00

Required Date: 5/13/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/05/04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3281

Rev F

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

x4

Jh

11/05/05

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp:

240°F

Time IN:

2:00 am

Time OUT:

7:00 am

11/05/05

x4

Jh

11/05/05

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
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NOTE: Date & initial all entries

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Page 2

Item ID: D3281-2L08

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Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Fwd RH

Start Date: 5/4/2011 Start Qty: 4.00



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Required Date: 5/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3281 and Folio FTA 008

Dwg. Rev. FFolio Rev. D

x4

DH
11/05/05

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

x4

DH
11/05/05

130

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

x4

DH
11/05/05

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69188

Page 4

Wednesday, May 04, 2011 11:40:50 AM

Item ID: D3281-2L08

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Fwd RH

Start Date: 5/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/5/11

YMF
1-05-11

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 04, 2011 11:40:47 AM

Page 1

Work Order ID: 69188

Parent Item: D3281-2L08

Parent Item Name: Floor Protector, Fwd RH



Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. A 10.02.24 New Issue LL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

MLEXS.118-90318-08

Purchased

No

100

sf

2,220.704

5

21.05263



Lexan Sheet

Location

Loc Qty

Loc Code

therm

2220.70472

2220.70472

113127

21.05263

Ph
11/05/09

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
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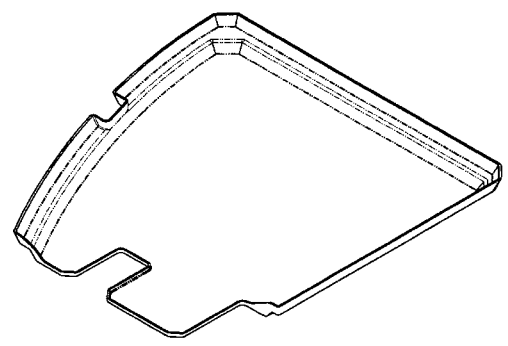
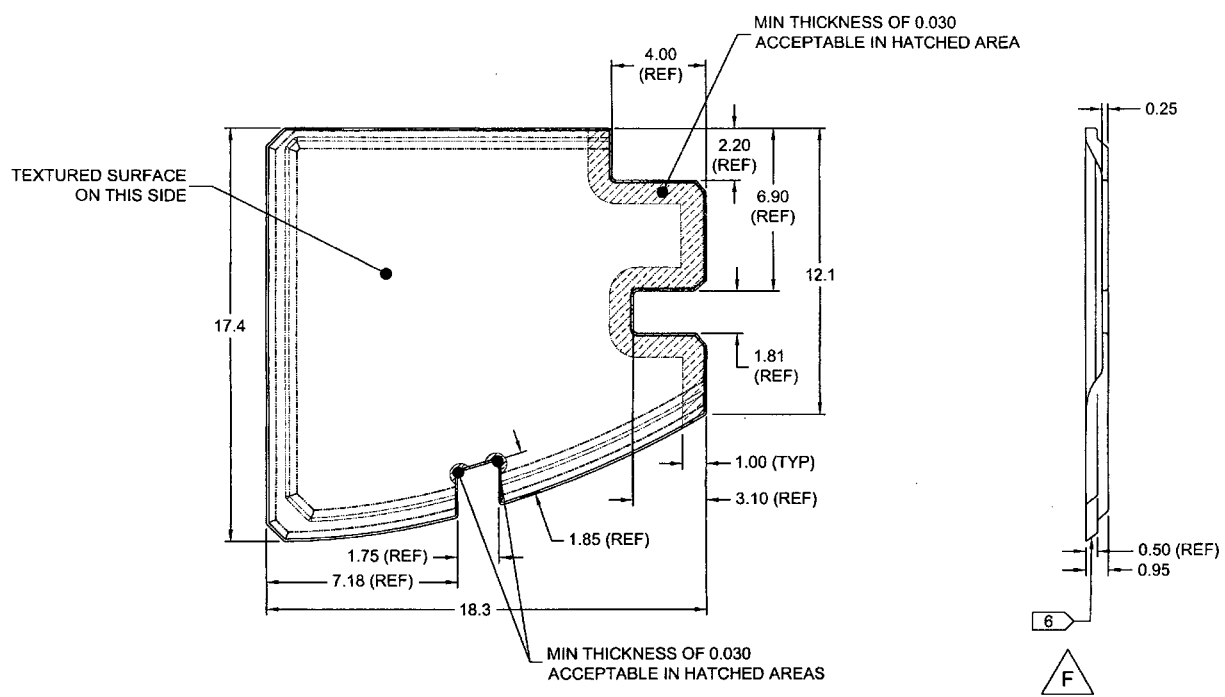
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3281-2 FLOOR PROTECTOR

RELEASED
R 2010-11-25

CL1105/04
W10:69188

- NOTES:**
- 1) MATERIAL: -2L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-2L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 MAX
 - 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-2Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
 - 7) WEIGHT: D3281-2L02 = 0.95 lb D3281-2L08 = 1.13 lb
 - 8) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

| | | | |
|--|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D3281 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FLOOR PROTECTOR | NTS |
| DATE | 10.09.27 | COPYRIGHT © 2004 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries

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|---|-------------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 69188 |
| Description: Floor Protector, Fwd RH | | Part Number: | D3281-2 |
| Inspection Dwg: D3281 | Rev: E / F | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than 0.1875" Go/No Go | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |

| | | | |
|---------------------|-----|--------------|----------|
| Measured by: | Wh- | Date: | 11/05/05 |
|---------------------|-----|--------------|----------|

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 18.3 | +/-0.100 | 18.25" | ✓ | | TAPE DL-01 | |
| 17.4 | +/-0.100 | 17.375" | ✓ | | TAPE DL-01 | |
| 12.1 | +/-0.100 | 12.06" | ✓ | | TAPE DL-01 | |
| 0.95 | +/-0.030 | 0.967" | ✓ | | Visual DL-02 | |
| 0.25 | +/-0.030 | 0.271" | ✓ | | Visual DL-02 | |
| 0.030 | Min | 0.054" | ✓ | | CAL TH-01 | |
| 0.070 | Min | 0.110" | ✓ | | CAL TH-01 | |
| | | | | | | |
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|------------------------------|-----|--------------|----------|
| Measured by: | Wh- | Date: | 11/05/09 |
| Audited by: | S | Date: | 11/05/09 |
| Preliminary Approval: | N/A | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------------|------------|----------|
| A | 08.02.28 | New Issue | KJ/DL | |
| B | 08.04.16 | Dimensions updated per Dwg Rev D | KJ/DL | |
| C | 08.07.23 | Dwg Rev updated | KJ/DL | |
| D | 08.09.12 | Tolerance revised for 0.070 dimension | KJ/DL | |
| E | 10.09.01 | Dwg Rev updated | KJ | Wh |